

Monday, 26/05/2008 9:58:57 AM

User:

Linda Lacelle

Process Sheet

Drawing Name

Part Number

Material

Due Date

Description:

304/316 .040 Sheet

Drawing Number

Project Number

Drawing Revision

Customer

: CU-DAR001 Dart Helicopters Services

Type

S.O. No. :

Job Number **Estimate Number** : 39479

: 13315

P.O. Number

: 26/05/2008 This Issue

: NC Prsht Rev.

First Issue

: // : 39420

Previous Run

Written By

Checked & Approved By

Comment

: Est Rev:A Est Rev:B

08-05-13

08-05-23 revA as per dwg DD verified by:EC

SMALL /MED FAB

new issue DD verified by:EC

: 02/06/2008

: WEARSHOE

: D3793 REVA

: D37933

: N/A

: A

Qty:

Each

Additional Product

Job Number:



Seq. #:

1.0

Machine Or Operation:

M304S20GA

Comment: Qty.:

1.3469 sf(s)/Unit Total:

26.9388 sf(s)

304/316 .040 Sheet (M304S20GA)

Batch:

2.0

WATER JET

Comment: FLOW WATER JET

1-Cut as per Dwg D3793

Dwg Rev:_

Prog Rev:

2-Deburr if necessary

INSPECT PARTS AS THEY COME OFF MACHINE

3.0

QC2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.0

BRAKE NO

NC BRAKE

Comment: NC BRAKE

1-Deburr if necessary

2-Form on Brake as per Dwg D3793 using Jigs

SD 08/05/27

Dart Aerospace Ltd

W/O:			V	ORK ORDER CH	ANGES					
DATE	STEP	PRO	CEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:		PAR #:	Fault Cat	tegory:	NCF	R: Yes N	No DQA :		Date:	
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NCR:		·	ORK ORI	DER NON-CONFO	RMANCE	(NCR)				
DATE	STEP	Description of NC	Initial	Corrective Action	Section B	Sign &	Verifica		Approval	Approval
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NOTE: Da	ate & initia	al all entries								<u> </u>

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Date: Monday, 26/05/2008 9:58:57 AM User: Linda Lacelle **Process Sheet Drawing Name: WEARSHOE** Customer: CU-DAR001 Dart Helicopters Services Job Number: 39479 Part Number: D37933 Job Number: Seq. #: Description: **Machine Or Operation:** 6.0 QC5 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP POWDER COATING POWDER COATING 7.0 **Comment: POWDER COATING** Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3 START TIME: **OVEN TEMPERATURE** FINISH TIME: INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 8.0 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE # 9.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock <u>08/05/</u>28 Location: FINAL INSPECTION/W/O RELEASE 10.0 QC21 Comment: FINAL INSI Job Completion

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Part No	:	PAR #:	Fault Category:		_ NCR: Yes	No DQA	:	_ Date: _	
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NCR:		W	ORK ORDER NON-	CONFORM	ANCE (NC	R)			
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NCR:	•	VV	WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC	Corrective Action Section B			Verification	Approval	Approval					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	ription Sign & Date		Approval Chief Eng	Approval QC Inspector					
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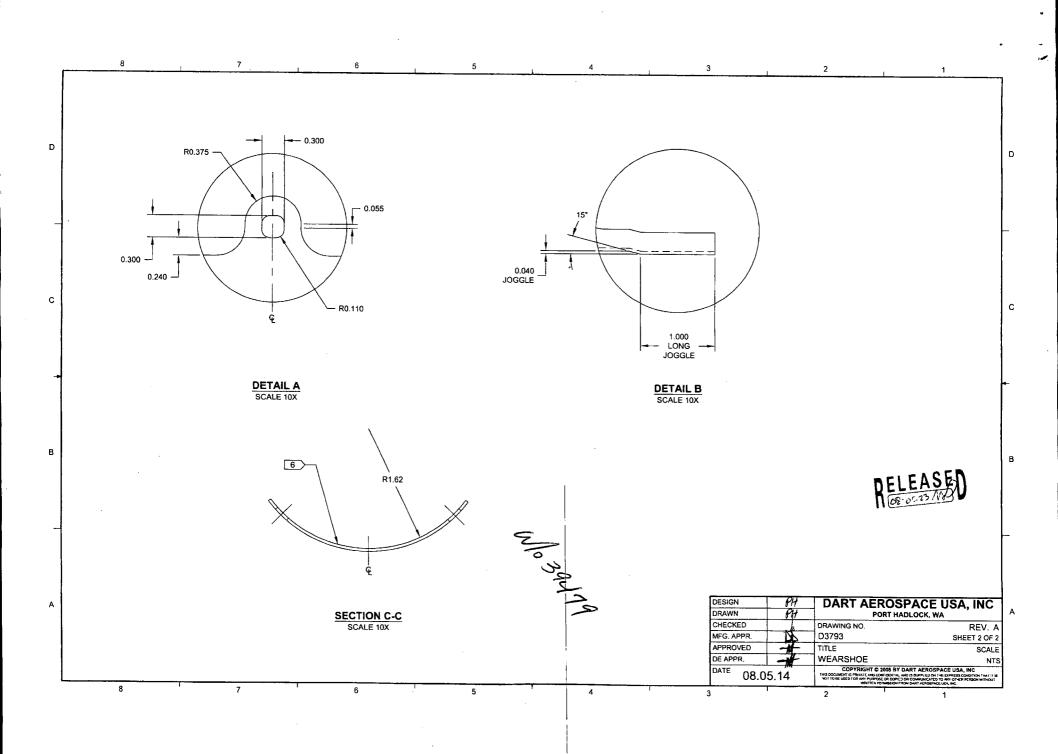
NOTE: Date & initial all entries

8 32.900 26.735 D D 29,400 17.750 27.400 23.900 -14.250 - 18.983 14.066 4.750 DETAIL A **— 2.000** 2.000 ---R0.57 Ģ. 1.885 4.389 6.547 8.00 1.885 Ø0.188 DETAIL A С 0.531x0.780 5.00 2 PL Ø0.188 6.00 ---OBROUND 2 PL **D3793-1F FLAT PATTERN D3793-3F FLAT PATTERN** 4.50 TO BEND LINE (ON FLAT -PATTERN) DETAIL B R31.6 0.32 ' В REF **D3793-1 BEND DETAIL** D3793-3 BEND DETAIL (MAKE FROM D3793-1F) (MAKE FROM D3793-3F) NEW ISSUE A PH 08.05.14 REV. DESCRIPTION BY DATE 1) MATERIAL: AISI 304/316 SS SHEET SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) DART AEROSPACE USA, INC DESIGN (REF DART SPEC M304S20GA) 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED DRAWN PH PORT HADLOCK, WA CHECKED DRAWING NO. REV. A 4) UNITS: INCHES UNLESS OTHERWISE NOTED MFG, APPR D3793 SHEET 1 OF 2 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX APPROVED TITLE SCALE 6) IDENTIFICATION: IDENIFTY WITH DART P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH DE APPR. WEARSHOE NTS 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS COPYRIGHT © 2008 BY DART AEROSPACE USA, INC DATE 08.05.14 8 6 5

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W/O:			WOF	RK ORDER CH	ANGES	·	111111111111111111111111111111111111111		
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NCR:			WORK ORDE	R NON-CONFO	DRMANCE	(NCR	2)		
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DATE	STEP	Section A	Initial	Action Descrip	otion	Sign &	Section C	, .	QC Inspecto

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
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NOTE: Date & initial all entries



DART AEROSPACE LTD	Work Order: 39479
Description: WEAR SHOF	Part Number: D 3793-3
Inspection Dwg: D3793-3 Rev: 4	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototy

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .188	100200.4	P81,) ie			
300×300	7- 1010	:301×301	X			
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Measured by:	B	Audited by:	0	/ 1	Prototype Approval:	N	1
Date:	8-5-26	Date:	Œ	05/27	Date:		7

Rev	Date	Change	Revised by	Approved
Α		New Issue	KJ/JLM	

